

* NEED ① PRINTED

Kush Feb 23

Work Order ID 141896 - 2

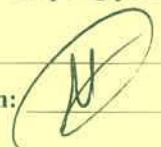
141896

Thursday, February 18, 2016 4:18:21 PM

Item ID: D3847-11 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*

Item Name: Wearpad
Start Date: 2/18/2016 Start Qty: 20.00 *20*
Required Date: 2/22/2016 Req'd Qty: 20.00 *20*

Cust Item ID:
Customer:

Reference:
Approvals: Process Plan: 
QC: _____

Date: 16-2-18 Tooling: _____ Date: _____
Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3847	C								

100 0.00
100
Waterjet Memo
FLOW CNC Waterjet 1-Cut as per Dwg D3847
Dwg Rev: C
Prog Rev: C
2-Debur if necessary

(20) 02/16/02/22

110 0.00
110
QC Memo
Quality Control

(20) 02/16/02/22

Thursday, February 18, 2016 4:18:21 PM

Page 2

[illegible]

Thursday, February 18, 2016 4:18:21 PM

Page 3

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

Work Order ID 141896

Thursday, February 18, 2016 4:18:21 PM

141896

Page 4

Item ID: D3847-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 2/18/2016 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 2/22/2016 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>m 130746</i> Memo START TIME: <i>10:50</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>11:20</i>	0.00 0.02				<i>1</i>	<i>0</i>	<i>16-02-23</i>	<i>34 34 34</i>
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>1</i>			DAS 41 9-89 16-2-23
193 *193* HandFinish Hand Finishing	Hand Finishing Memo APPLY TEXTURE COATING ON TOP CONCAVE SURFACE AS PER DWG TEXTURE COATING BATCH: <i>134278</i>	0.00 0.00				<i>1</i>			DAS 41 9-89 16-2-23

Work Order ID 141896

Thursday, February 18, 2016 4:18:22 PM

141896

Page 5

Item ID: D3847-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad
 Start Date: 2/18/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 2/22/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
196 *196* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>①</u>			<u>DAS</u> <u>38</u> <u>3-89</u> FFR 23 2016
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-09</u> Memo LOCATION ; FP001	0.00 0.00				X1	d	21	16/02/23
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.03							16/2/24 <u>AD</u> Sht 20160223

Picklist Print

Page 1

Thursday, February 18, 2016 4:18:25 PM

Work Order ID: 141896

141896

Parent Item: D3847-11

D3847-11

Parent Item Name: Wearpad

Start Date: 2/18/2016

Required Date: 2/22/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No			sf	143.8500		3.564211			

M304S16GA

304/316 Sheet .063

**

Dec 16 / 02 / 22

Location

Loc Qty

Loc Code

MAT019

143.85

m134067

47.85

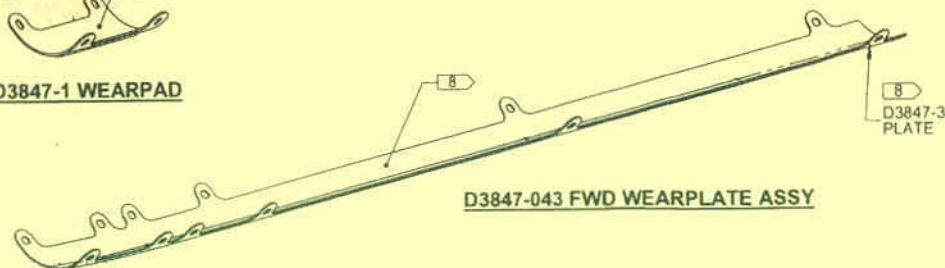
m134158

96

32



D3847-1 WEARPAD



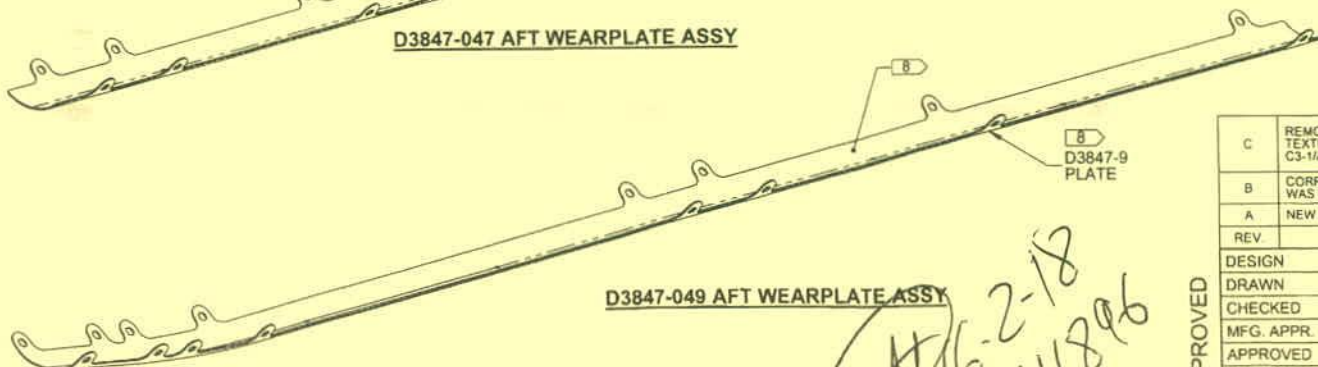
D3847-043 FWD WEARPLATE ASSY



D3847-045 AFT WEARPLATE ASSY



D3847-047 AFT WEARPLATE ASSY



D3847-049 AFT WEARPLATE ASSY

ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
31	A/R	A/R	A/R	A/R	TEXTURED COATING	SEALANT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3847-043 = 1.48 lbs
D3847-045 = 1.29 lbs
D3847-047 = 1.70 lbs
D3847-049 = 4.88 lbs
- 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9



D3847-11 WEARPAD

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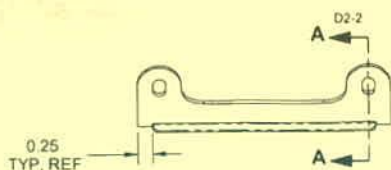
2014 NOV 24

ECN 14-428

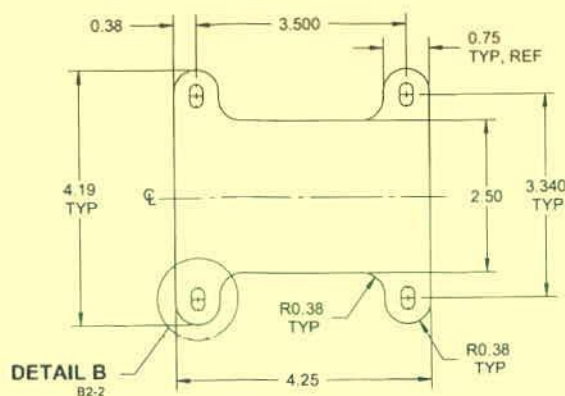
C	REMOVED D3846-3/-5/-7/-9 GASKETS, ZN D2-1, ADDED TEXTURED COATING, ZN B3-1, UPDATED WEIGHTS, ZN C3-1/A8-2	AK	14.08.06
B	CORRECT TYPO D3847-047 WAS D3847-045, ZN B5-1, 5.82 WAS 6.25 (ZN A4-2), 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AK	KENT, WA	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3847	SHEET 1 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	D9	WEARPLATE ASSY	NTS
DATE	14.08.06	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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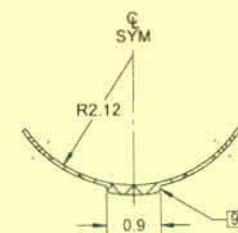
16-2-18
141896



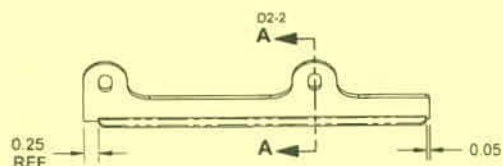
D3847-1 WEARPAD
MADE FROM D3847-1F FLAT PATTERN



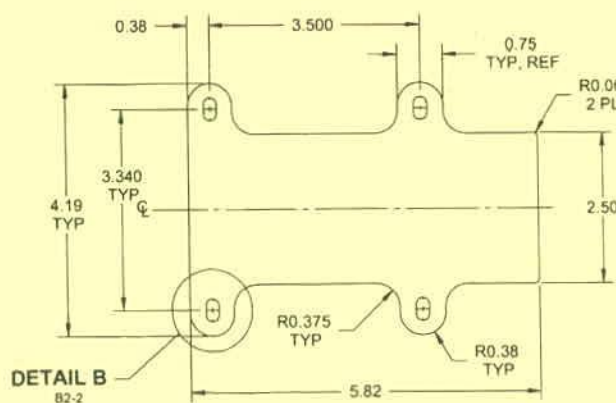
D3847-1F FLAT PATTERN



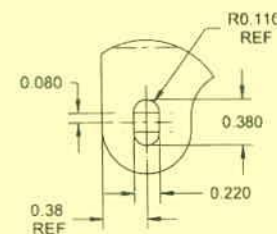
SECTION A-A D7-2
B7-2



D3847-11 WEARPAD
MADE FROM D3847-11F FLAT PATTERN



D3847-11F FLAT PATTERN



DETAIL B C5-2
B5-2
TYP, SCALE 2X

NOTES:

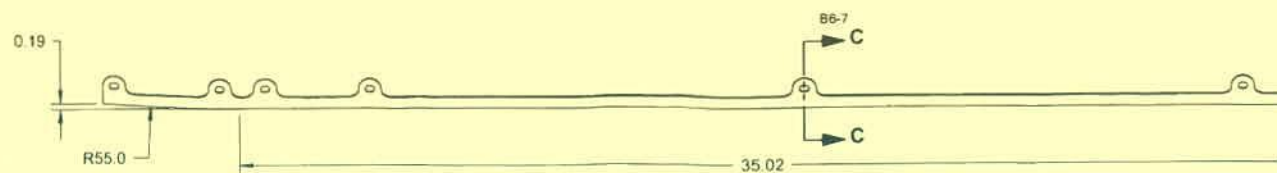
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
D3847-1 = 0.32 lbs
D3847-11 = 0.47 lbs
- 8) WELD PER QSI 004
- 9) APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.19 TO 0.25 THICK UNLESS OTHERWISE INDICATED

RELEASED

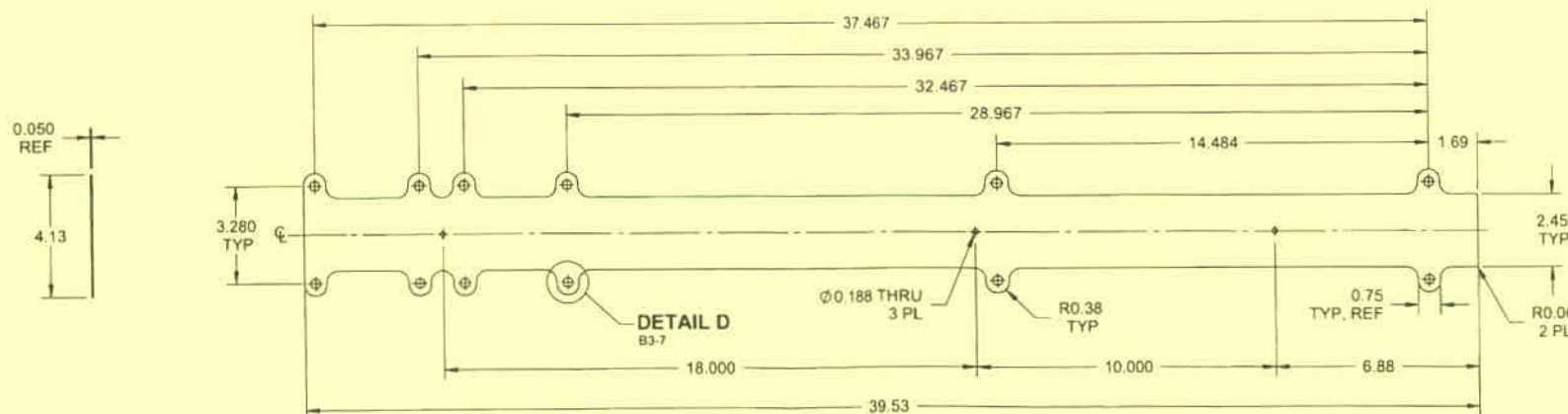
2014 NOV 24

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MFG. APPR.	JLM	D3847	SHEET 2 OF 7
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DE APPR.	DS	WEARPLATE ASSY	NTS
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D3847-3 PLATE
MADE FROM D3847-3F FLAT PATTERN



D3847-3F FLAT PATTERN

RELEASED

2014 NOV 24

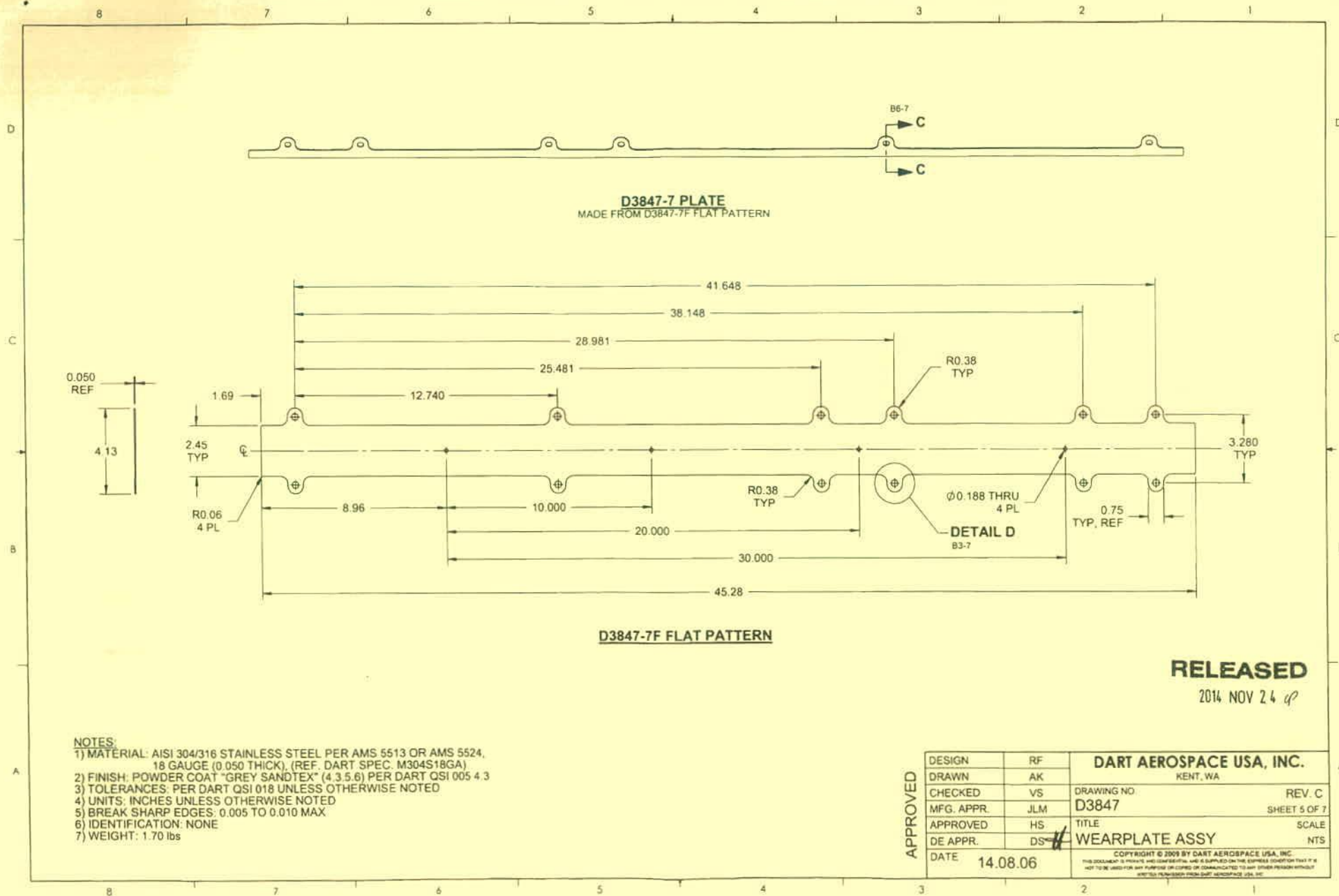
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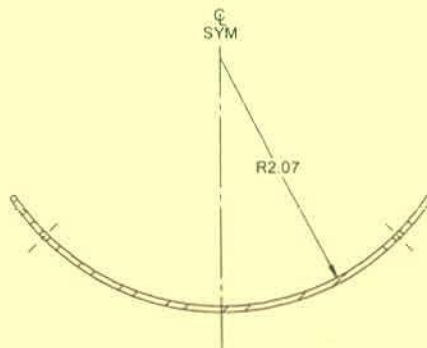
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDING" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.48 lbs

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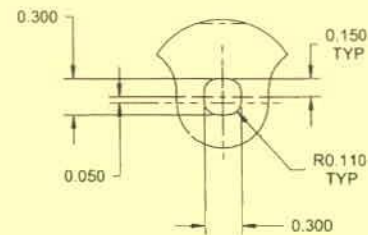
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SECTION C-C
SCALE 4X

D4-3
D4-4
D3-5
D3-6



DETAIL D
TYP. SCALE 4X

B5-3
B6-4
B3-5
B5-6

RELEASED

2014 NOV 24 49

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	CHECKED	VS	DRAWING NO. D3847	REV. C
	MFG. APPR.	JLM	SHEET 7 OF 7	
	APPROVED	HS	TITLE WEARPLATE ASSY	SCALE NTS
	DE APPR.	DS		
	DATE	14.08.06		

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